

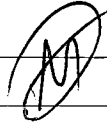
Work Order ID 163079

Wednesday, June 21, 2017 11:17:25 AM

163079

Page 1

Item ID: D5336-044 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly, RH
 Start Date: 7/14/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/20/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference: SCHEDULED

Approvals: Process Plan:  Date: JUN 21 2017 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5336	B								
100	Weld per dwg A/R S.S. rod Batch 4130067	0.00						DAS 43	
100	Large Fab							9-89	JUL 16 2017
Large Fab	Memo	2.03							
Large Fab	1- Assemble ribs , weld as per dwg D5336 using DT10196								
	2- Weld hinge (2) and locking brackets as per dwg D5336								
	inspect before welding mesh								
	3- Cut mesh as per dwg D5334-3								
	4- Tack weld mesh on basket as per dwg D5336								
	Make sure to place mesh correctly on lid, check with label plate before tacking mesh								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									
								DAS 9 9-89	

h **17.07.24**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
WORK ORDER NO. _____				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				1			DAS 38 9-89
150									
QC	Memo	0.01							
Quality Control									JUL 26 2017
160	Identify as per dwg & Stock Location: <u>W/L</u>	0.00							
160									
Packaging	Memo	0.01							
Packaging									10 of 20 17/02/20
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.10							
Quality Control									17/7/26 JG



JUL 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, June 21, 2017 11:17:24 AM

Page 1

Work Order ID: 163079

163079

Parent Item: D5336-044

D5336-044

Parent Item Name: Basket Lid Assembly, RH

Start Date: 7/14/2017

Required Date: 7/20/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4016-3		Manufactured	No			100	Each	95.0000	2	2		DAS 43 9-89	JUL 03 2017
✓ *D4016-3*													
Hinge Half, Lid													

Location	Loc Qty	Loc Code
WA004	95	
159554	25	
159570	20	
160518	50	

D5333-1		Manufactured	No			100	Each	10.0000	1	1		DAS 43 9-89	JUL 03 2017
✓ *D5333-1*													
Locking Bracket													

Location	Loc Qty	Loc Code
WA004	10	
159811	10	

M304EX0.75-16F		Purchased	No			100	sf	716.9000	4.8	5.052632		DAS 43 9-89	JUL 16 2017
✓ *M304FX0 75-16F*													
Expanded Metal Flat SS													

Location	Loc Qty	Loc Code
WA004	716.9	
M136991	13.9	
M137294	223	
M137765	480	

D5332-043		Manufactured	No			100	Each	1.0000	1	1		DAS 43 9-89	JUL 03 2017
✓ *D5332-043*													
Rib Assembly													

Location	Loc Qty	Loc Code
WA004	1	
159812	1	

DQA: _____ Date: _____

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Page 2

Work Order ID: 163079

163079

Parent Item: D5336-044

D5336-044

Parent Item Name: Basket Lid Assembly, RH

Start Date: 7/14/2017

Required Date: 7/20/2017

Start Qty: 1.00

Required Qty: 1.00

D5332-7 Manufactured No

100 Each 1.0000 1 1

✓ *D5332-7*

Rib

**B159813 → 1x DAS 43 JUL 03 2017 9-89

Location Loc Qty Loc Code

WA004

1

159813

1

D5332-9 Manufactured No

100 Each 1.0000 1 1

✓ *D5332-9*

Rib

**B163103 → 1x DAS 43 JUL 03 2017 9-89

Location Loc Qty Loc Code

WA004

1

159814

1

D5332-11 Manufactured No

100 Each 1.0000 1 1

✓ *D5332-11*

Rib

**B163108 → 1x DAS 43 JUL 03 2017 9-89

Location Loc Qty Loc Code

WA004

1

159815

1

D5332-15 Manufactured No

100 Each 3.0000 1 1

✓ *D5332-15*

Rib

**B159822 → 1x DAS 43 JUL 03 2017 9-89

Location Loc Qty Loc Code

WA004

3

159816

1

159822

2

DQA: _____ Date: _____



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								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐																	

Picklist Print

Wednesday, June 21, 2017 11:17:24 AM

Work Order ID: 163079

163079

Parent Item: D5336-044

D5336-044

Parent Item Name: Basket Lid Assembly, RH

Start Date: 7/14/2017

Required Date: 7/20/2017

Start Qty: 1.00

Required Qty: 1.00

D5332-17

Manufactured No

100

Each

2.0000

2

2

DAS

✓ *D5332-17*

Rib

**B159817 → 2x

43

9-89

JUL 03 2017

Location

Loc Qty

Loc Code

WA004

2

159817

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

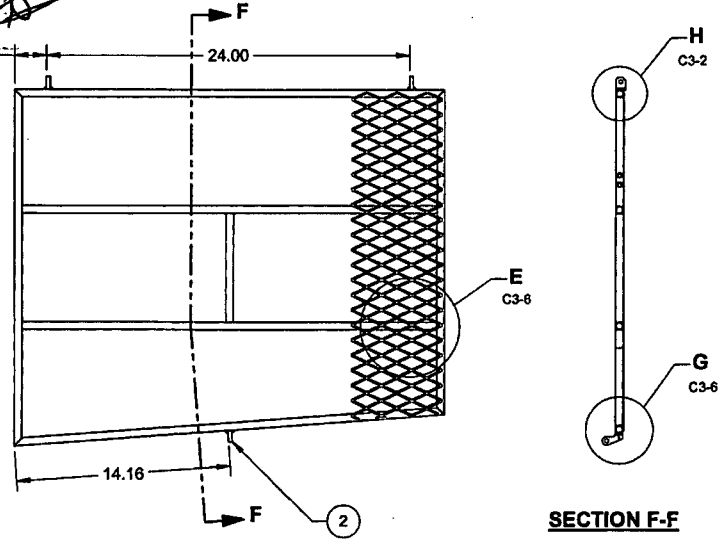
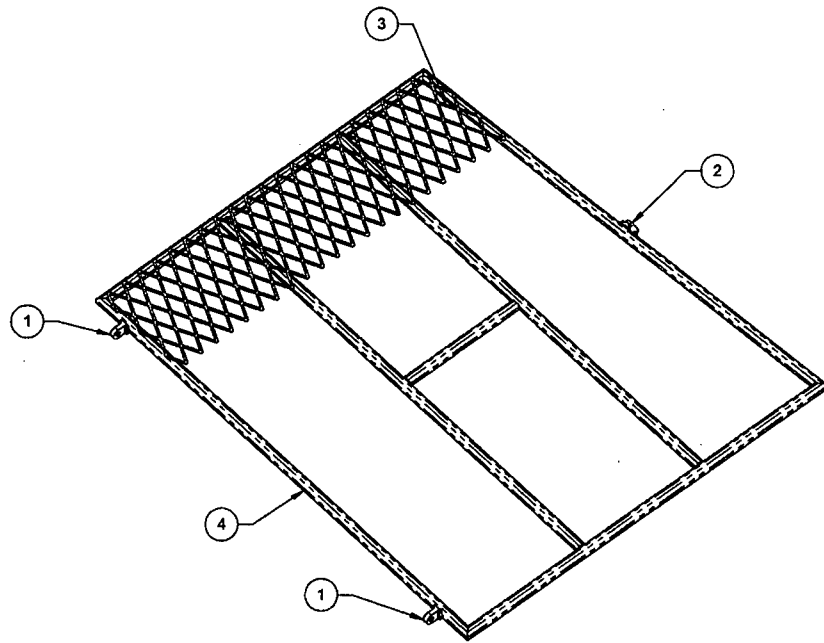
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

ITEM	QTY -044	P/N	DESCRIPTION
	X	D5336-044	BASKET LID ASSY, RH
1	2	D4018-3	HINGE HALF, LID
2	1	D5333-1	LOCKING BRACKET
3	1	D5334-3	LID MESH
4	1	D5336-103	TUBULAR ASSEMBLY, LID

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163078

JUN 21 2017



D5336-044 BASKET LID ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

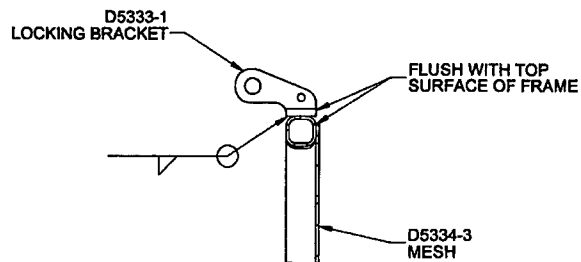
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 6.4 lbs
- 8) MASK HOLES PRIOR TO FINISHING
- 9) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.06 UNLESS OTHERWISE NOTED FOR D5336-044
- 10) WELD PER DART QSI 004

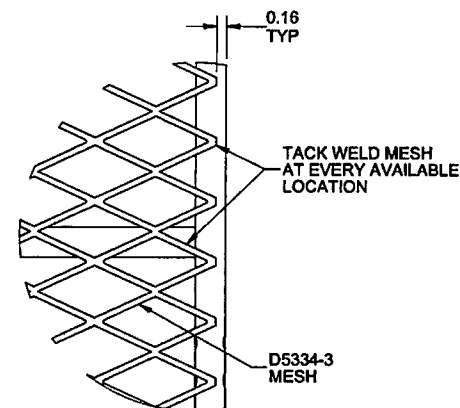
RELEASED
2017-03-22

APPROVED

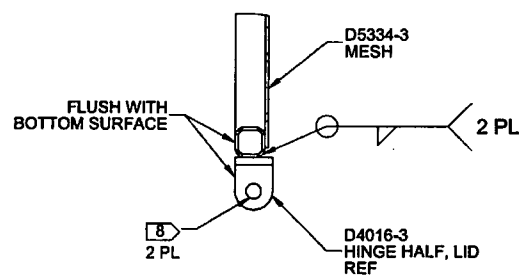
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5336	SHEET 5 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66/R44 BASKET LID ASSY	NTS
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DETAIL G
(-043 SHOWN, -044 OPPOSITE)
C1-4
B1-5



DETAIL E
C2-4
C2-5



DETAIL H
(-043 SHOWN, -044 OPPOSITE)
B1-4
C1-5

RELEASED
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5336	SHEET 6 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66/R44 BASKET LID ASSY	NTS
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